

Date: Wednesday, 1/4/2006 2:37:18 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: STEP SPACER		
Job Number	: 25395D		Part Number	: D2279		
Estimate Number	: 10356		Drawing Number	: D2279 REV D		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 1/4/2006		S.O. No.	: N/A		
Prsht Rev.	: NC		Type	: SMALL /MED FAB		
First Issue	: N/A		Material	:		
Previous Run	: 25089D		Due Date	: 1/25/2006		
Written By	: <u>SEE COMMENT Below</u>		Qty:	30		
Checked & Approved By	: <u>SEE ABOVE USER</u>		Um:	Each		
Comment	: Est Rev: A New Issue 05-11-07 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M2024T3S040	2024-T3 .040 sheet	
		Comment: Qty.: 0.1544 sf(s)/Unit Total : 3.0870 sf(s) Material: 2024-T3 sheet (QQ-A-250/4) 0.040" Thick (M2024T3S.040) Identify as D2279 Batch: M19295	
2.0	SHEAR	SHEAR	
		Comment: SHEAR Cut blanks: (4.70" x 4.50") -0.00/+0.020" (grain along 4.50")	JL 06-02-01 30
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per folio D2279, use stack of 15	JL 06-02-01 30
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	JL 06-02-01 30
5.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	M8 06/02/01 30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/02/24
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

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Job Number: 25395D	Part Number: D2279
Job Number:	
Seq. #:	Machine Or Operation:
6.0	SMALL FAB 1
	SMALL & MEDIUM FAB RESOURCE 1
Comment: SMALL & MEDIUM FAB RESOURCE 1	ml 06/02/03 (30)
Deburr	
7.0	BRAKE NC
	NC BRAKE
Comment: NC BRAKE	SB 06/02/16 (30)
Form As per Dwg D2279	
8.0	QC5
	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP	J 06.02.17 30
9.0	HAND FINISHING1
	HAND FINISHING RESOURCE #1
Comment: HAND FINISHING RESOURCE #1	
Chemical Conversion Coat as per QSI 005 4.1	SAD 06/02/18 (30)
10.0	QC3
	INSPECT POWDER COAT/CHEMICAL CONVERSION
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION	J 06.02.20 30
11.0	PACKAGING 1
	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1	
Identify and Stock	
Location: GA 5	SB 06/02/23 (30)
12.0	DC
	DOCUMENT CONTROL
Comment: DOCUMENT CONTROL	
Inspection Level 21	(30)
Job Completion	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

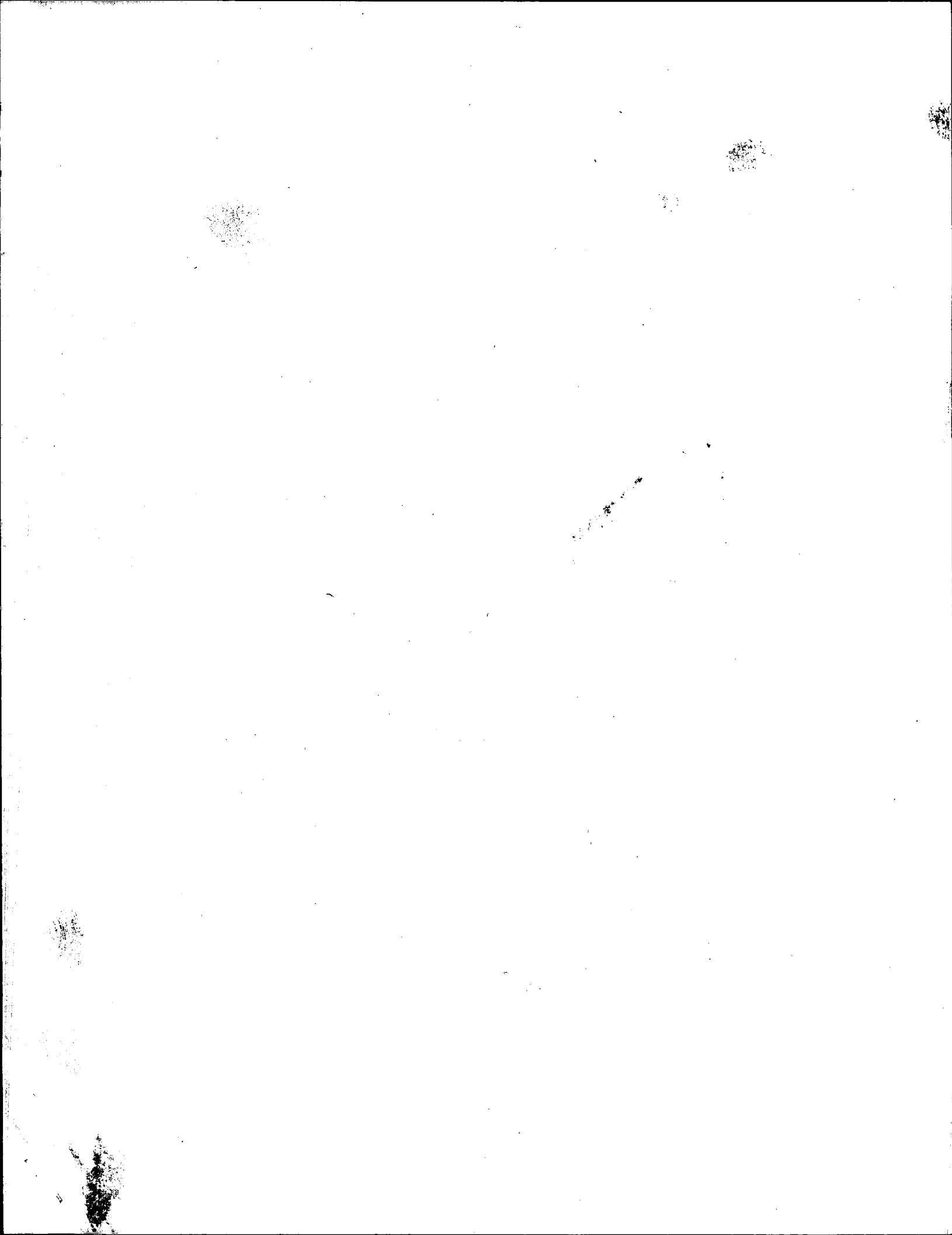
DART AEROSPACE LTD	Work Order:	25395D
Description: Step Spacer	Part Number:	D2279
Inspection Dwg: D2279	Rev: D	Page 1 of 1

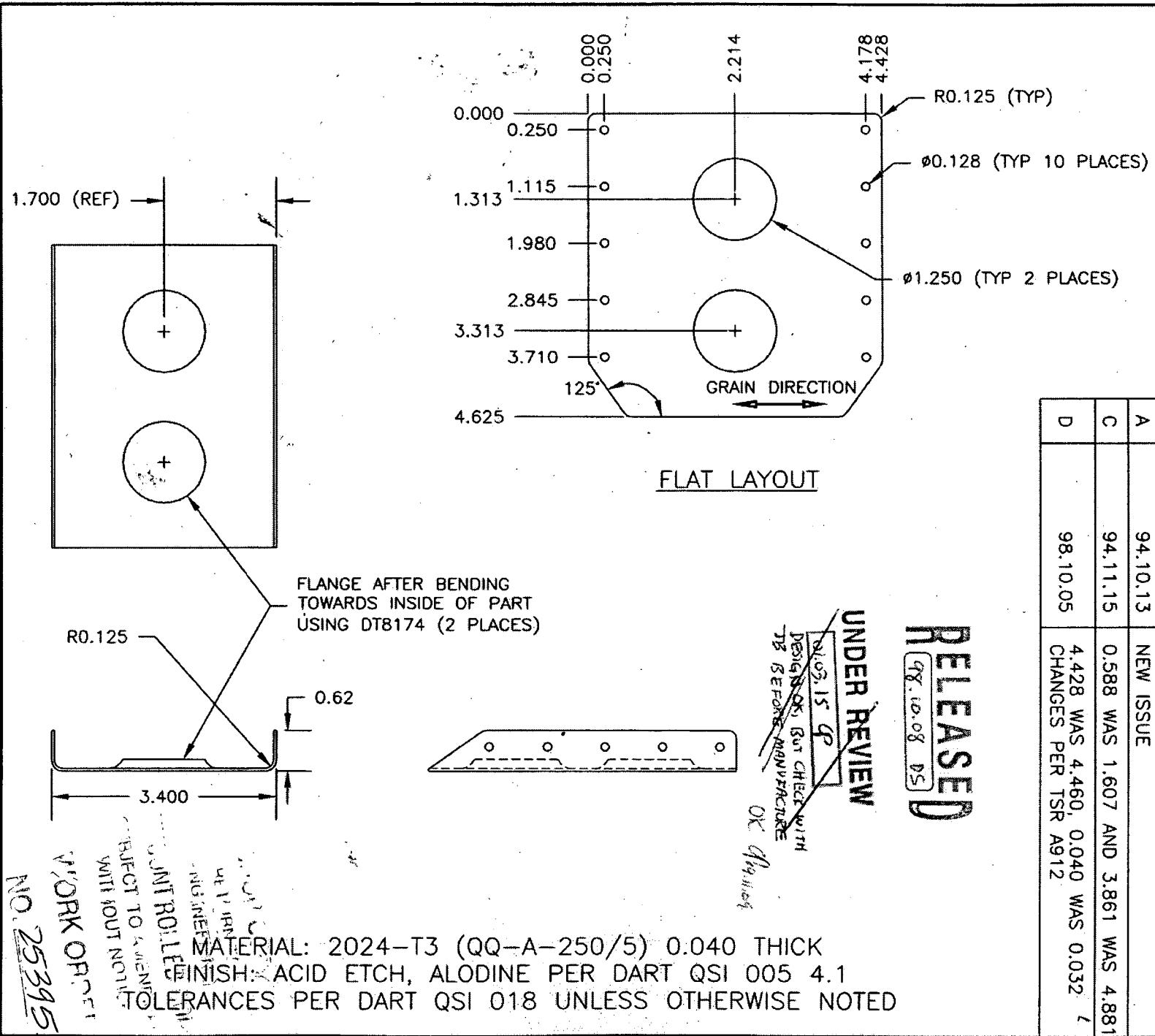
FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	J.L	Audited by:	MS	Prototype Approval:	N/A
Date:	06.02.01	Date:	06/02/01	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.10.12	New Issue P/O D2582	KJ/JLM	





DART

QC APPROVED
DRAFT

DESIGN BY	DRAWN BY	DART AEROSPACE LTD
BW	CP	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
RE	RE	D2279
DATE	RE	REV. D
98.10.05	RE	STEP SPACER
TITLE	RE	SHEET 1 OF 1
	RE	SCALE
	RE	1:2

RELEASED
98.10.08 DS

UNDER REVIEW
98.10.15 CP
DESIGN OK BUT CHECK WITH
TB BEFORE MANUFACTURE
OK CP. 98.10.08

